

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04559

SHEET 1 OF 1

DWG NO. 646.9700

REV: C

PREPARED BY

D. MEJIA

DATE: 06/11/2014

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

*[Signature]*

MFG

*[Signature]*

QC

*[Signature]*

EFF.

NEXT ORDER

TRANSACTION CODES (TC):  
A-ADD  
R-REVISE  
C-CREATE  
D-DELETE

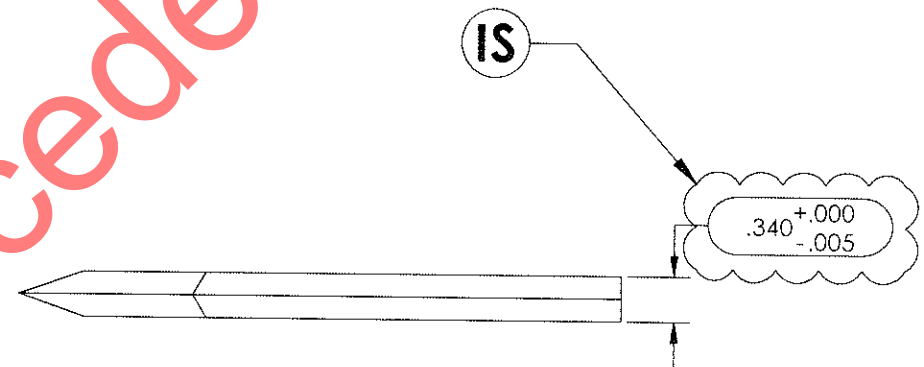
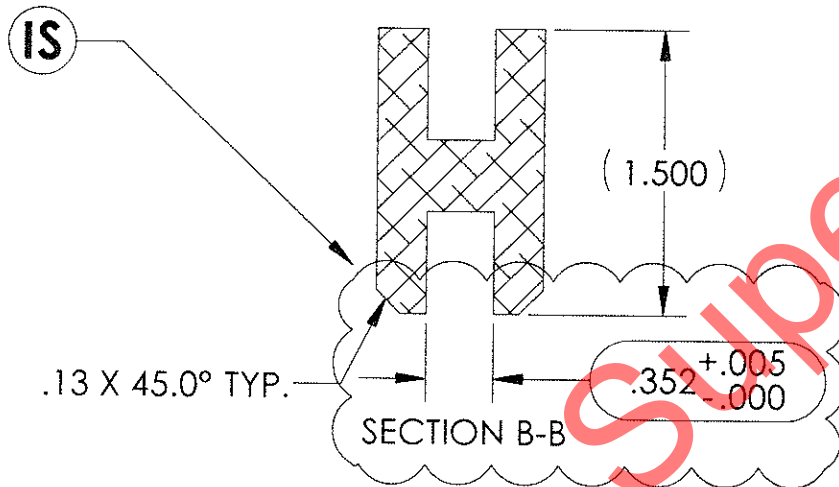
REASON: ADDED DIMENSION AND TOLERANCE

ECR:

D-14-05

**SHEET 2, ZONE D7 IS:**

**SHEET 5, ZONE B5 IS:**



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

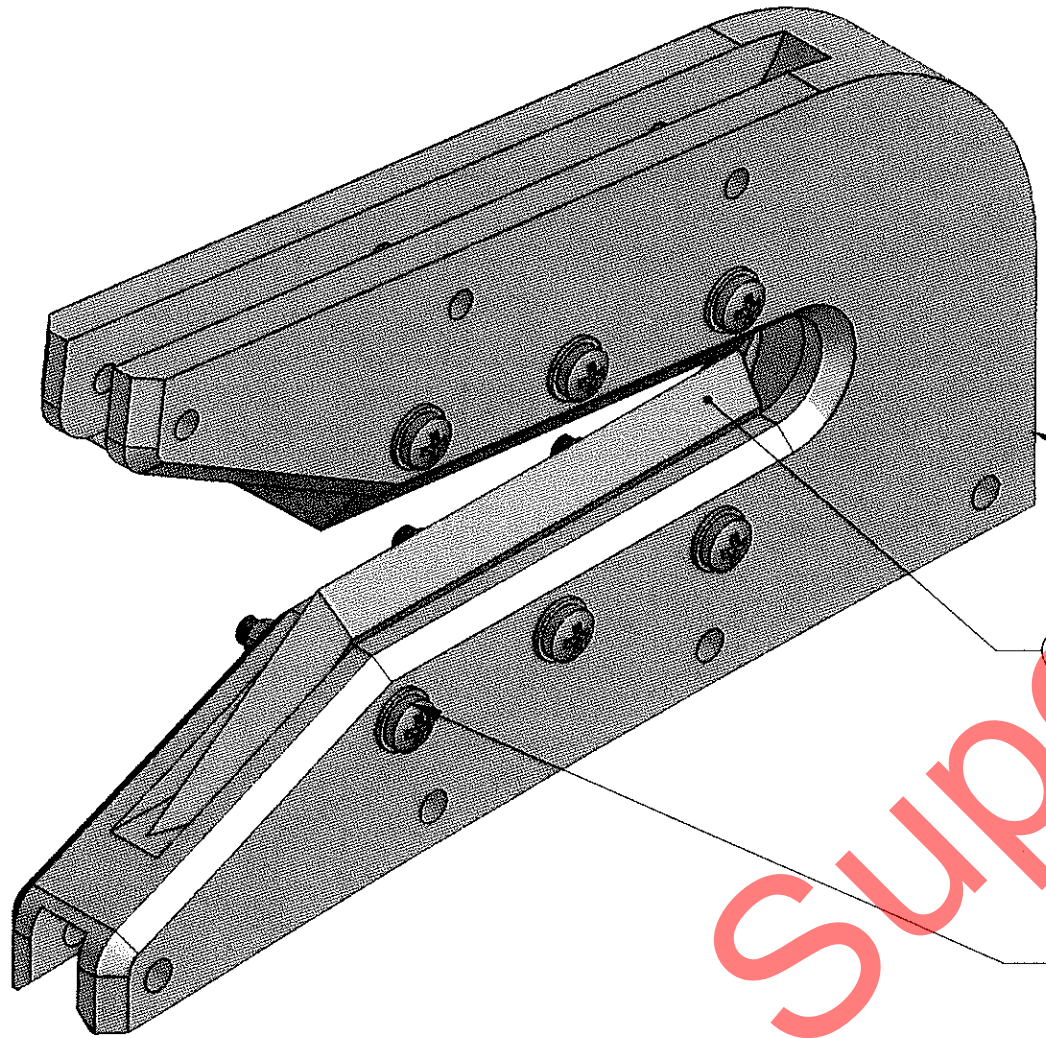
☐ YES ☒ NO

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		M/C
N/C	INITIAL RELEASE	05/29/09	P. BRAVO
A	INCORPORATED ECN 02744, 03836, 03912	06/06/13	P. BRAVO
B	INCORPORATED ECN 03967	07/03/13	P. BRAVO
C	INCORPORATED ECN 04039	08/09/13	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL  
CONDITION: ANNEALED  
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



2 2PL

3 6PL  
4 12PL  
6 6PL

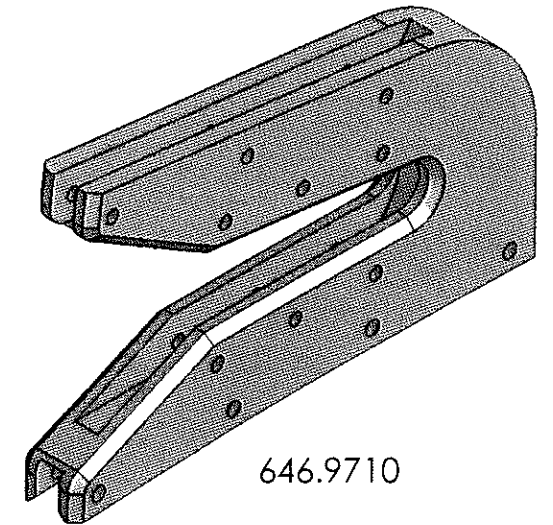
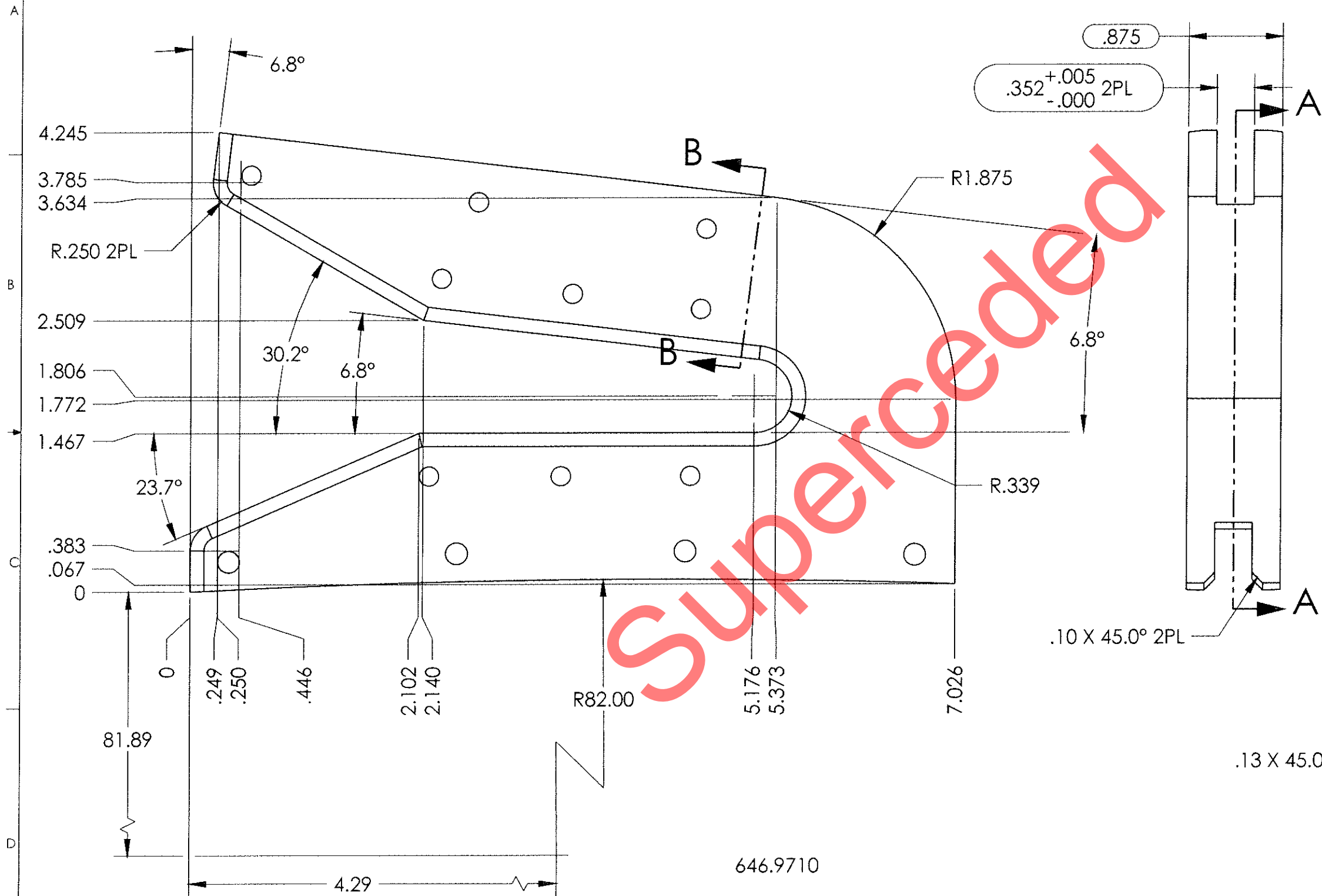
646.9701  
or  
646.9702

UNINCORPORATED ECN(s)

04559

1	7	646.9712	BODY (U CHANNEL)	1	2/9
6	6	601.1541	LOCKNUT	MS21042L08	
A/R	A/R	5	601.2764	RTV, LOCTITE 598	
12	12	4	601.2764	WASHER	NAS11491N832P
6	6	3	601.2765	SCREW	MS27039-0819
2	2	2	646.9711	BLADE	3
	1	1	646.9710	BODY	2
			646.9702	CUTTER SUB ASSY (U CHANNEL)	
			646.9701	CUTTER SUB ASSY	
9702	9701	FIND #	PART #	DESCRIPTION	MAT'L SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
646.9600			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
			CUTTER SUB ASSY		
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		
			SIZE B	CAGE CODE 07M26	DWG. NO. 646.9700
			SCALE NONE		
			SHEET 1 OF 6		

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.10 X 45.0° 2PL

.13 X 45.0° TYP.

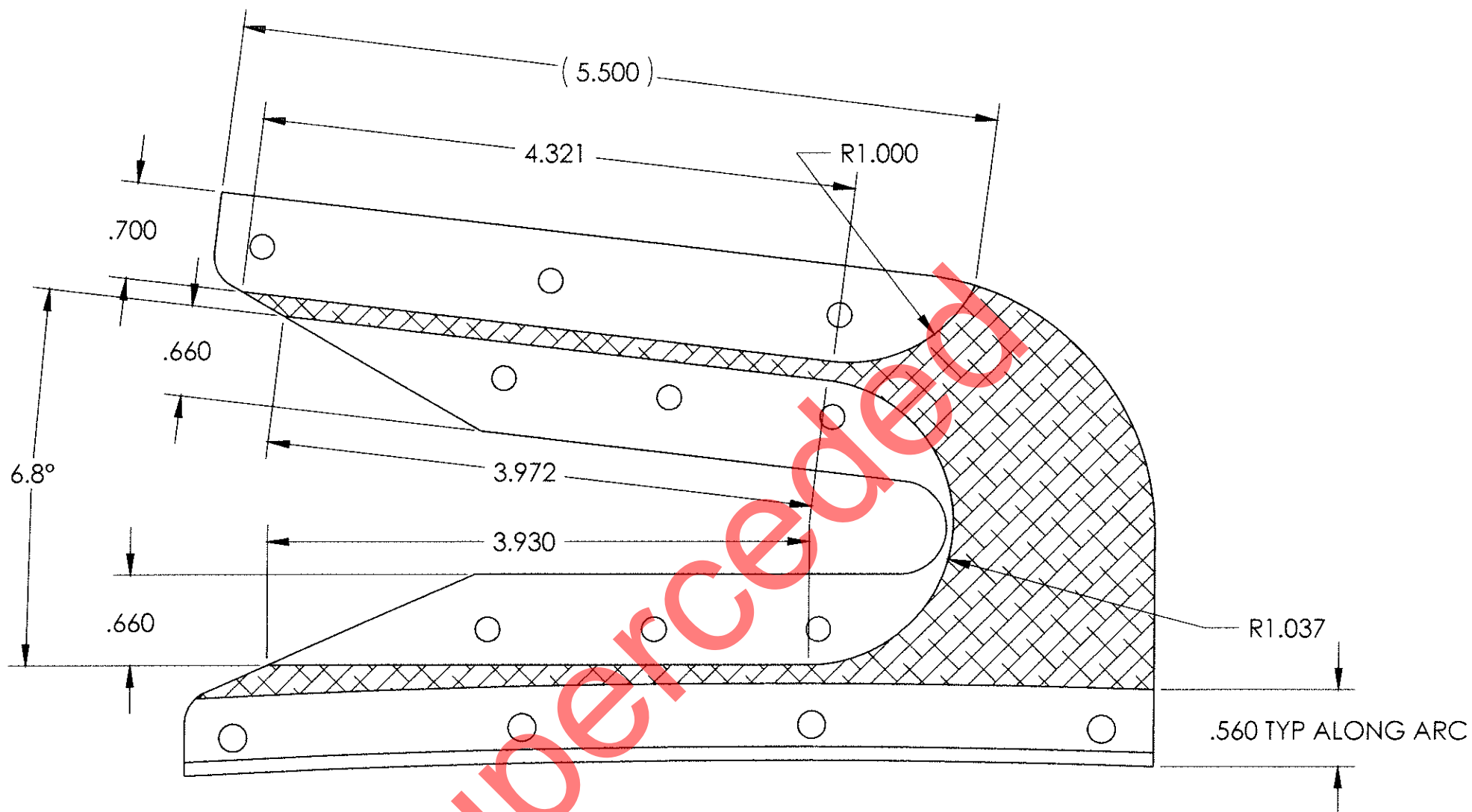
SECTION B-B

3  
B4

(1.500)

ORIGINAL DATE (MO. DAY. YR.) 05-29-09		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKER F. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL F. BRAVO		CUTTER SUB ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SITE B	REV. C
		SCALE: NONE	SHEET 2 OF 6

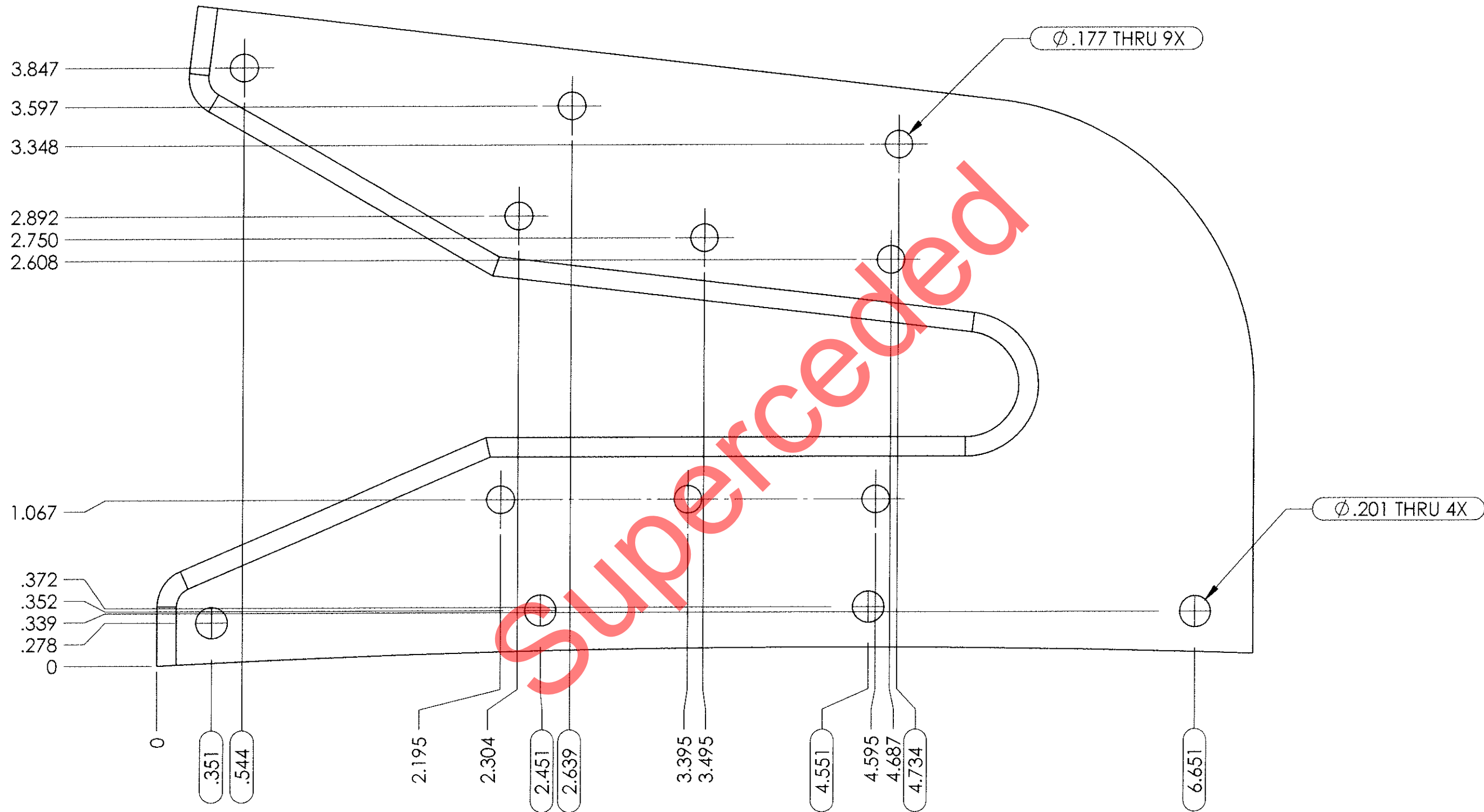
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ORIGINAL DATE (MO-DA-YR) 05-29-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY R. ROSANO	CHECKER P. BRAVO		
DRAWING APPROVAL P. BRAVO 05-29-09		CUTTER SUB ASSY	
CONTRACT NO.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		DWG. NO. 646.9700	
		SCALE NONE	SHEET 3 OF 6



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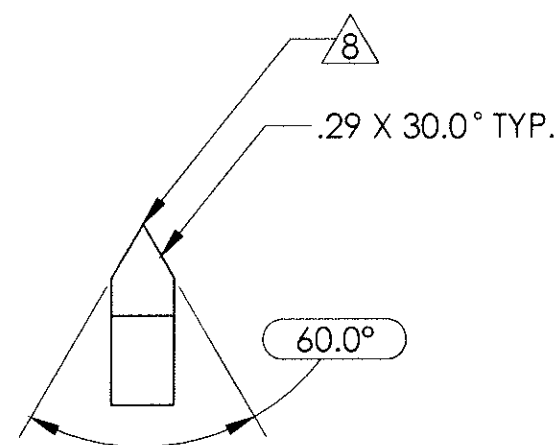
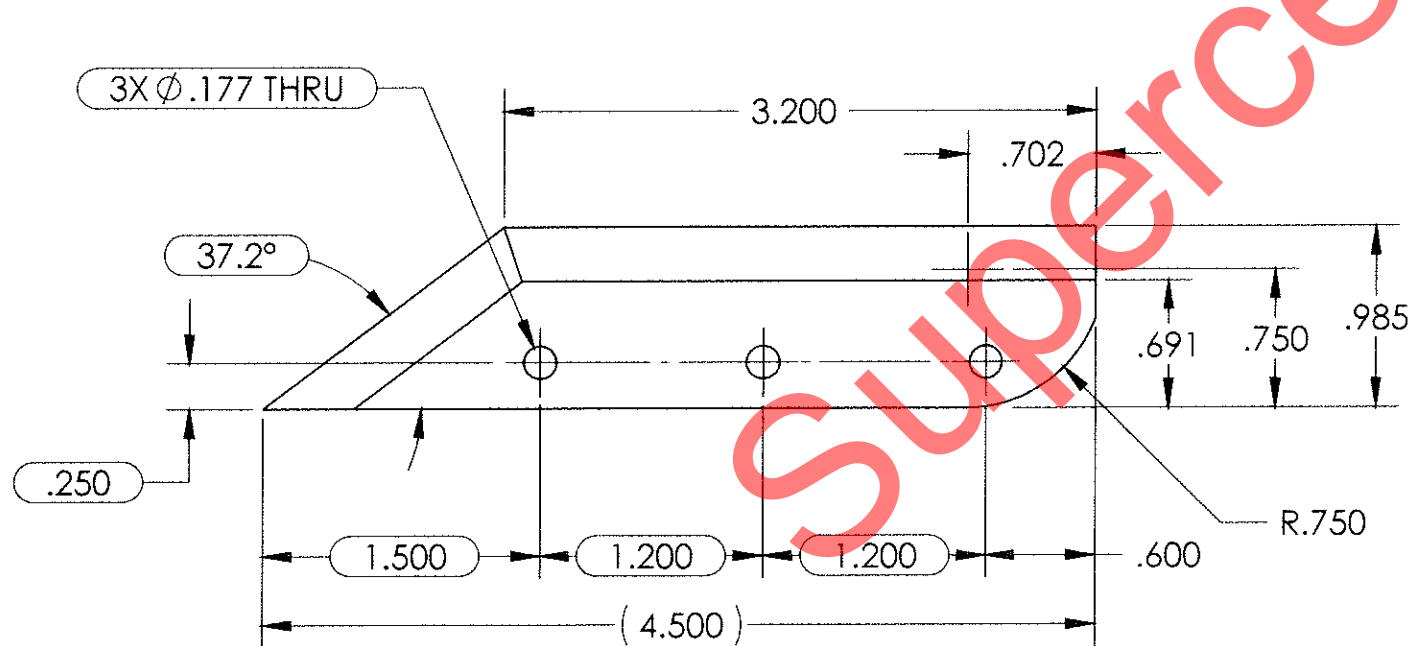
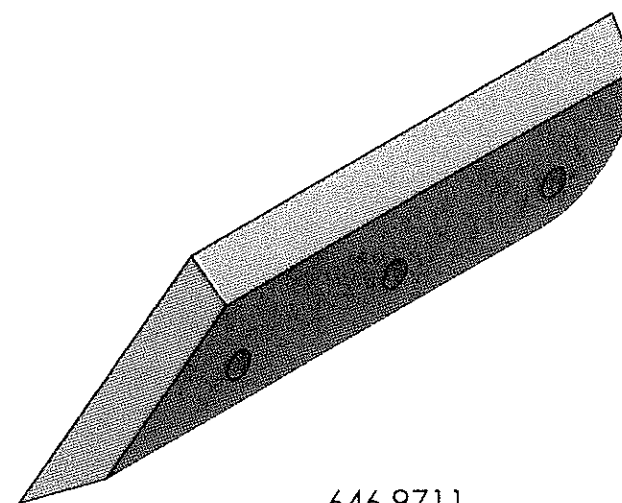
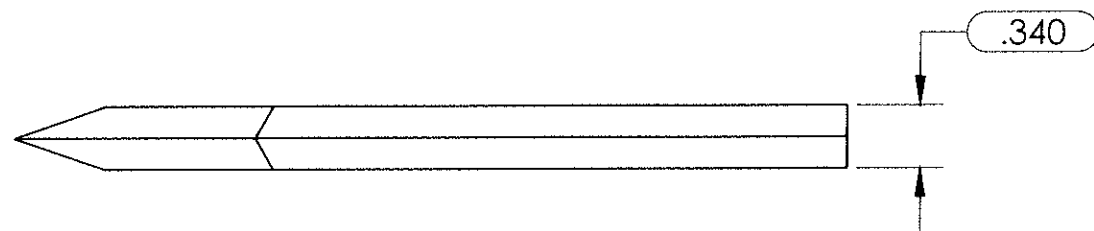


HOLE LOCATIONS +/- .002

646.9710

ORIGINAL DATE 1/10/04-1/11/04 05-29-09		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER P. BRAVO		CUTTER SUB ASSY	
DRAWING APPROVAL P. BRAVO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
CONTRACT NO.		SIZE B	REV. C
		CAGE CODE 07M26	DWG. NO. 646.9700
		SCALE NONE	SHEET 4 OF 6

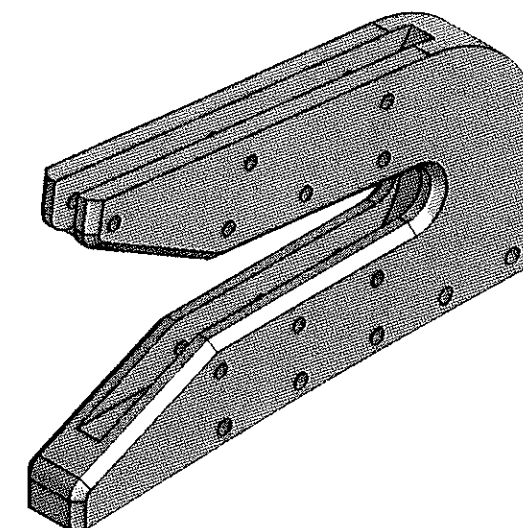
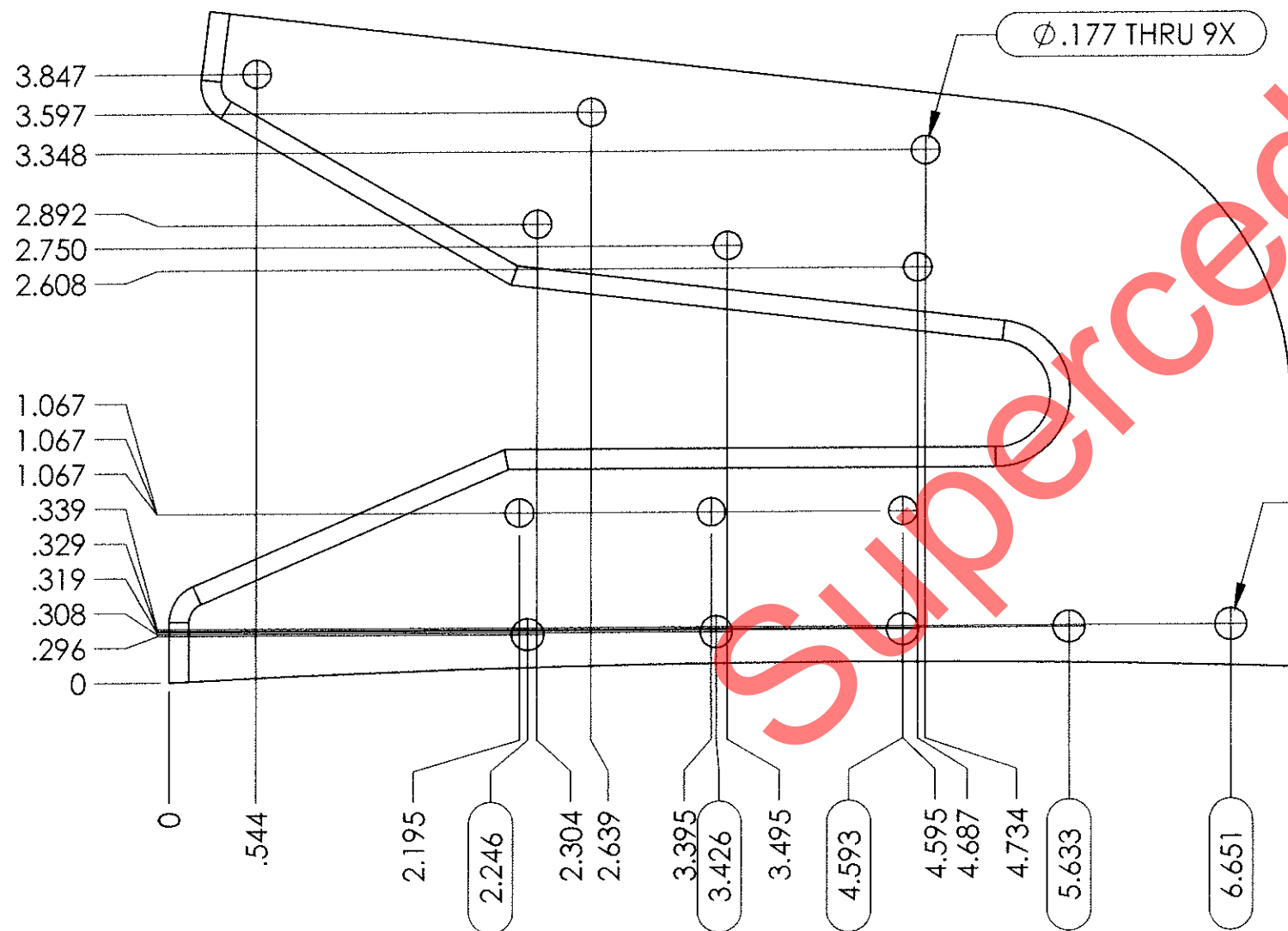
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646.9711

ORIGINAL DATE (MO-DA-YR) 05-29-09		APICAL INDUSTRIES	
DRAWN BY P. ROSARIO		2608 TEMPLE HEIGHTS DR.	
CHECKER P. BRAVO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		CUTTER SUB ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHT B	REV. C
CAGE CODE 07MZ6		DWG. NO. 646.9700	
SCALE NONE		SHEET 5 OF 6	

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646.9712  $\triangle 9$

646.9712

ORIGINAL DATE (MO, DA, YR) 05-29-09		APICAL INDUSTRIES	
DRAWN BY R. ROSANO	CHECKER P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 05-29-09		CUTTER SUB ASSY	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .03$ 3 PLACE DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		SHEET B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 646.9700
		SCALE NONE	SHEET 6 OF 6